Work Order ID 101204

Friday, May 03, 2013 2:24:34 PM

101204



Friday, May 03	3, 2013 2:24:3	14 PM									
Item ID: Revision ID: Item Name:	D3136-043 Window Asse	mbly		Accept	* N 900	040	100)* s	Setup Sta Sto	1.71	S1* S2*
Start Date: Required Date Reference:	5/3/2013 e: 5/6/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6 *6		Cust Item I Customer:	ID:				ı	. 17
Approvals:	Process Pla QC:	in: MF	Date: 13	5-3 Tooling: SPC (Y/N):	ř	ate: ate:		F	Run Sta	1/1	R1* R2*
Sequence 1D/ Work Center I Draw Nbr	·	Operation Description ision Nbr		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3136 100 *100* Waterjet FLOW UNC Water Plexiglass		FLOW WATER JET Memo 1-Cut as p	_ E_	0.00				6	6		Jm13~08-14
110 *110* OC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				6	Ō		JM13.08-14
*120 *120* QC Quality Control		QC8- Inspect parts - se	cond check	0.00				3	3		Ah. 13/08/14 PTO-7

•											DQA!	JUIZ Da	te:	13/08/92
NCR: Y	es/	/ No			4	WORK ORDER NON-	CO1	NFORI	MANCE / UPI	DATE	QA Closed:	~ 11		13/08/21
Work Orde	ar.	(< 1	120	4		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	٠. ٥٥٠	D3	36-		•	Rework Scrap >> Use-as-is Work Order Update		ì	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec/Sto	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root			,		Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	4	or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		13/08/14	120	3	CHIP SCR Chippe legun	AT LEAD IN OUT. And 3. d begons is limitating	A G	5AS 16 9-8	Reprogrammove Lea forther of Surger is	en to adiaforet comparts.	3/00/14 13/00/14	13.8.15	>	DAS 16 2-8 002042 13/05/14
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	<u> </u>	Bending			<u> </u>	Bend	L	Grain			Ovalized		<u> </u>	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	ire		Over/Under	tolerance		Temperature/Cure
	L	Cracks				Broken/Damaged	L	Inspect	ion Incomplete	<u></u>	Part Incorred	ct	<u></u>	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/U	Unclear	Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Water sand and buff to remove scractches as required

Thermoforming Machine

DAS 07 13/00/14

Page 2

Insp.

Stamp

											DQA:	Dat	te: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	 Dat	to:	
						T					· ·			
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part N	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	$\overline{}$				Descri	tion of work order update		nitial	Act	tion	Sign &		Т	
Cause		Date	Step	Qty	i '	or Non-conformance		ief Eng		ription	Date	Verification	,	QC Inspector
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	$\boldsymbol{\vdash}$	Crushed/0	Crimped		<u> </u>	Burrs	-	Į.	ions Incomplete/	Unclear	Part Lost/Mi	ssing	\	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved			
	\vdash	Heat Trea				Countersink	\vdash	Mislabe		<u> </u>	Positioned V		_	
	${f -}$	Inspection		Tube	<u> </u>	Cut Too Short	\vdash	Misread	ļ	<u> </u>	Power Loss/	Surge		Other
\ \	-	Ripples in			<u> </u>	Drill Holes	—	Offset						
	Ш.	Torque W	aves in E	Extrusio	n [_	Drawing	L	Out of 0	Calibration					

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence Wave/Twist in Tube Finish

Folio

0.00

Memo

3x M.W. 13-08-16

180

Packaging

Packaging

NCR:	Yes	1	No
		,	110

NCR: Y	es / No				WORK ORDER NON	-coi	NFORI	MANCE / UPE	OATE	,	DQA: QA Closed:		ate: _	
Work Orde	er:			• ¹ /	DISPOSITION				AGAINST		PARTMENT			
Part N	lo				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaginį Supplie		Engineering Quality Other
		1		Descri		_	Initial	Act	<u> </u>		Sign 9		· —	
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance		initial iief Eng	Descr			Sign & Date	Verification	,,	QC Inspector
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Landir	ng Gear				General		1			_			_	
	Cracks Crushed, Cuffs Heat Tre	lot Conce /Crimped		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4	ion Incomplete ions Incomplete/L enance eled	nclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/5	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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		Naves in I	Extrusion	,	Drawing		4	Calibration		+	· · · · · · · · · · · · · · · · · · ·			
	_	Sequence		<u> </u>	Finish		4	Sequence		-				
	Wave/Tv	wist in Tul	be		Folio		Outside	Dimensions		-				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 101204

Friday, May 03, 2013 2:24:34 PM

Item ID:

D3136-043

Accept

Revision ID:

Item Name:

Window Assembly

Start Date:

5/3/2013

Start Qty: 6.00

Required Date: 5/6/2013

Reg'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

QC:

Date:

QC21- Final Inspection - Work Order Release

SPC (Y/N):

Sequence ID/ Work Center ID Operation Description

Set Up/ Run Hours

190

190

QC.

0.00 Memo

Quality Control

Cust Item ID:

N900040100

Date:

Date:

Customer:

Run

Stop

Setup Start

Tool ID

Tool# Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

										DQA:	Da	te:	
NCR: Y	es /	No			WORK ORDER NON-	COI	NFOR	MANCE / UPDATE				_	
										QA Closed:	Dat	te:	-
Mark Onde					DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS		
Work Orde	er				Rework	۱ ۲		Skid-tube Crosst	ube	1	Water Jet		Engineering
Part N	No.				Scrap	-		Machining Small		Pro	d. Eng. Coor.	$\boldsymbol{\vdash}$	Quality
					Use-as-is	1	Thern	noforming Finish	ning	Rec/Sto	re/Packaging		Other
NCR N	No				Work Order Update]		Large Fab Compo	site]	Supplier		
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Operator				1								-	
Material		1											
Setup		ŀ									1		
Other													
Process						1						- 1	
Supplier			-									-	
Training												İ	
Unapproved							_						
					F	AUI	LT CATE	GORY					
Landi	ng Gear			_	General		_			_			
	Ben	ding			Bend		Grain			Ovalized			Pressure/Forced
	Cen	re Not Con	centric t	o O/S	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Crac	ks		ſ	Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct		Weld
	Crus	hed/Crimp	ed	Γ	Burrs		Instruct	tions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled
	Cuff	S			Contamination		Mainte	enance		Part Moved	•		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Picklist Print

Friday, May 03, 2013 2:24:32 PM

Work Order ID:

101204

Parent Item:

D3136-043

Parent Item Name:

Window Assembly

Comments:

JPP Rev:A04.02.04New issucKJ/DS

IPP Rev.B 07.05.29

Thermoform in-house DL

IPP rev C 07.09.28 Rev E dwg

EC verified by:DD IPP Rev:D 10.06.24 added note in qc5

seq 170 DD verf.EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3108-9 Decal		Manufactured	No			100	Each	496.0000	2	12		Sl.
				Location ST026 3455 4654		Loc Otv 496 18 478		e Code	\leq	6		13/08/15.
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			170	sť	519.7445	3.9	23:4	28	Jm 1308

Location	Loc Qtv	Loc Code	
MAT019	176		
123704	33		
123949	71		
124559	72		<u> </u>
ther	343.7445		7.
123895	343.7445		

Page 1

Start Date: 5/3/2013

Required Date: 5/6/2013

Start Qty: 6.00

Required Qty: 6.00

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE			
										<u></u>	QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Ord	or:				ı	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOLK OIG	ет.					Rework	1	1	Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR	No.					Work Order Update]	i	Large Fab	Composite]	Supplier	
D		•	<u> </u>	T	Dogori	ption of work order update		Initial	Δ.		Sign &		[
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Equip/Tooling	Н]				İ				
Operator													
Material	Н]	
Setup	H												
Other	П												
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1	-	Cracks			<u> </u>	Broken/Damaged	\vdash	1	on incomplete	<u> </u>	Part Incorre		Weld
	-	Crushed/	Crimped			Burrs	_	1	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	<u></u>	Mainte		<u> </u> _	Part Moved		
		Heat Trea	ət			Countersink		Mislabe	led	<u> </u>	Positioned V		1
l	1	Inspectio	n Strip in	Tube	1	Cut Too Short	1	Misread	j		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

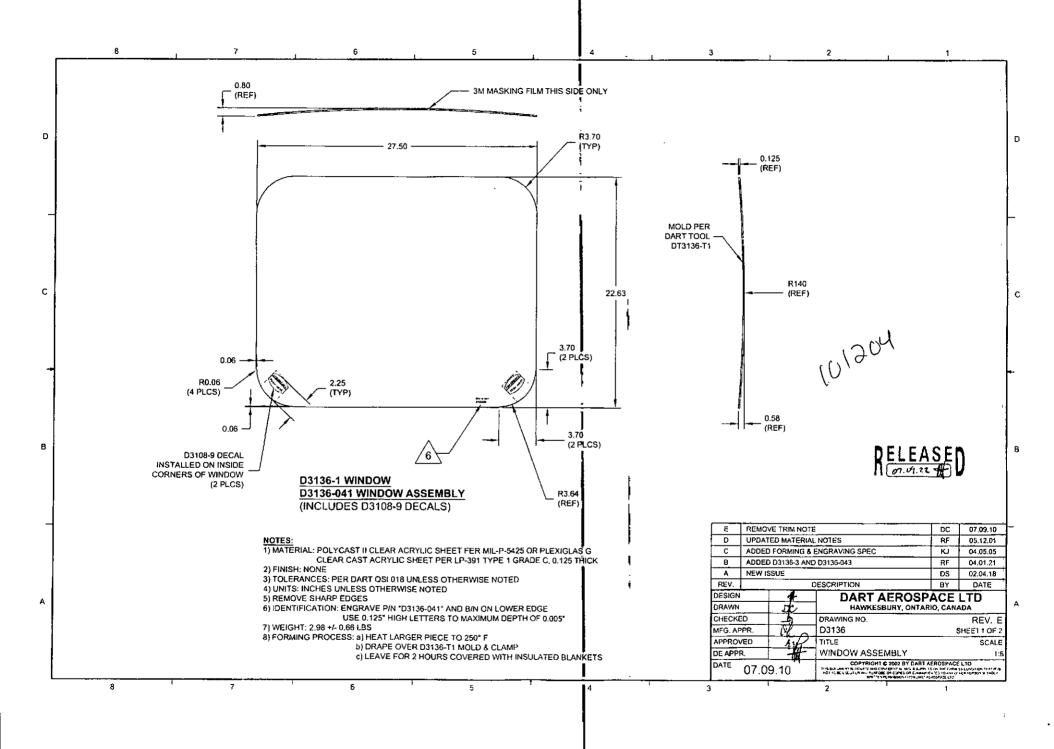
Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion



NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP[DATE			
									_		QA Closed	: Dat	e:
Work Orde	er: _					DISPOSITION	_			p	EPARTMEN	_	7
Part I	•					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other
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Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
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		Torque V	vaves in E	extrusio	n	Drawing		JOut of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date: _

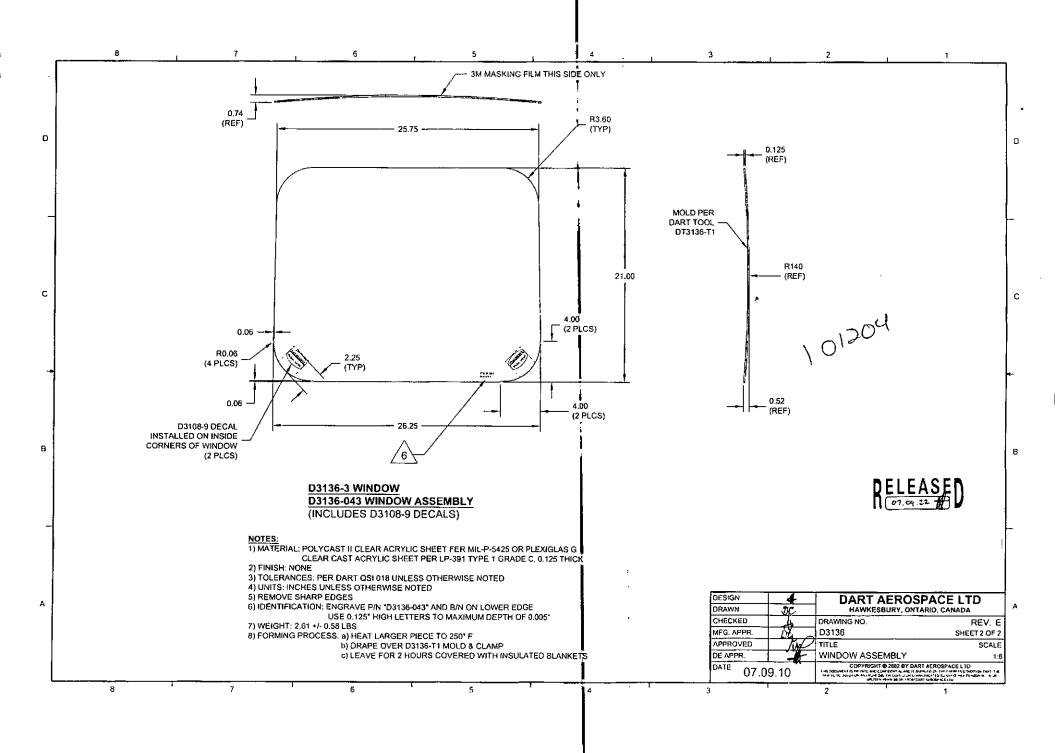
Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



										DQA:	Date:	
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										QA Closed:	Date:	
35.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
-1					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
No.					I —				Small Fab	Pro	├	Quality
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\vdash		or Concer	nunc to	″³	- 		i		 -	4		Weld
┉━		Crimned		<u> </u>	i -		1 '		Unclear	-	 	Wrong Stock Pulled
		cimpeu			-	\vdash	4	•		-		1.2.28 2/20// 1 2///20
-		+		<u> </u>		\vdash	ł		 		Vrong	
Н			Tube	<u> </u>	Cut Too Short	\vdash	1			₹		Other
	lo	ng Gear Bending Centre No Cracks Crushed/C Cuffs Heat Trea	Date Step Date Step Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat	Date Step Qty Date Step Qty Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs	Date Step Qty Descri Date Step Qty Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat	Part Step Oty Description of work order update or Non-conformance Date Step Oty Description of work order update or Non-conformance	Per:	Per:	Primary Control No. DISPOSITION Rework Skid-tube Machining Thermoforming Large Fab No. Description of work order update Initial Acc Chief Eng Description of work order update Chief Eng Description of work order update Initial Acc Chief Eng Description of work order update Initial Acc Chief Eng Description of work order update Chief Eng Description order update Chief Eng Description order update Chief Eng Description order update Chie	Pr: DISPOSITION Rework Skid-tube Crosstube Small Fab Thermoforming Large Fab Composite	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: AGAINST DEPARTMENT, Skid-tube Machining Small Fab Finishing Composite No.	DISPOSITION Rework Scrap Use-as-is Work Order Update

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Torque Waves in Extrusion

Turning Sequence ,

Wave/Twist in Tube

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 101	24
Description: Window Assembly	Part Number: C	3136-043
Inspection Dwg: D3136 Rev: E	P	age 1 of 1

)	First Arti	cle	_ Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
21.00	+/-0.030	21.00	_		7		 ,
25.75	+/-0.030	25,75	_		7		
26.25	+/-0.030	26.25	_		T		
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easured by:	Jm	Audited by:	125	JA. [Prototype Appr	oval:	N/A
	3-08-14	Date:	R/D	/		Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.10.19	New Issue	KJ/EC/DD
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